

Date: Thursday, 21/09/2006 11:14:53 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	3.540" SKID TUBE "I" BEAM
<b>Job Number</b> :	28673		
<b>Estimate Number</b> :	12466		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2963125
<b>This Issue</b> :	21/09/2006	<b>Drawing Number</b> :	D2963 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	21/09/2006	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	27775	<b>Material</b> :	
	<b>Type</b> :	<b>Due Date</b> :	10/10/2006
		<b>Qty:</b>	163
		<b>Um:</b>	Each
<b>Written By</b> :			
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:A New Issue 06-06-20 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 2097

C 206/09/21 (163)

- a) Extrude as per Dwg D2963
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum tensile yield strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Pull test required

2.0	D2963125P	105 I Beam Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 163.0000 Each(s)  
 105 I Beam Extrusion

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** Ensure Certification and tests are attached

206/10/10

(190)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

- Inspect dimensions per Dwg D2963
- Check Pull test per Dwg D2963 for compliance page attached.
- Check hardness with Webster tester

207 01 06

(190)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: R Date: 07/09/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 21/09/2006 11:14:53 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3.540" SKID TUBE "I" BEAM

Job Number: 28673

Part Number: D2963125

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Hallway in the back*

*2070106  
190*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



*(190)*

Comment: FINAL INSPECTION/W/O RELEASE

*20710108*

Job Completion



*U 2070108*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

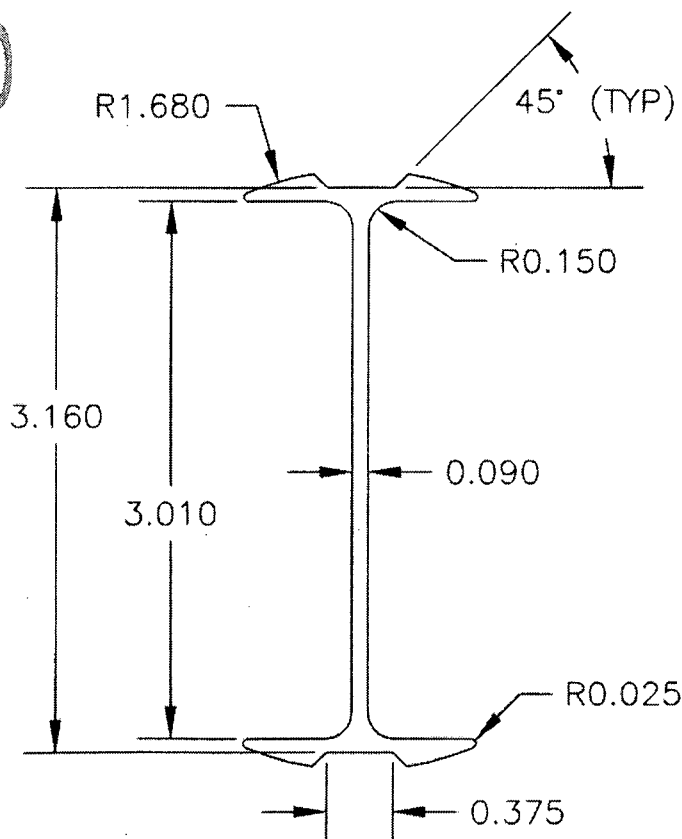
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2963	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE EXTRUSION	SCALE 1:1
A	00.03.10	NEW ISSUE	

RELEASED  
00.05.11

REFERENCE ONLY



#### GENERAL NOTES

1. MANUFACTURED USING BON L CANADA DIE # ~~TBD~~ DAA-848294 *00.06.08*
2. ORDER AS D2963-XXX WHERE XXX = LENGTH IN INCHES  
EG. 84 LONG: D2963-084 *00.06.08*
3. MATERIAL: 6061-T6 (QQ-A-200/8)  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

4. BREAK ALL UNMARKED SHARP CORNERS 0.016-0.025
5. NO TOOLING MARKS.
6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
7. ALL DIMENSIONS ARE IN INCHES.

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**BON L CANADA INC**500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No	Sales Order	Page
10/09/06	148500	41311	1
Cust PO	B/L No	Lot	Date
2097	00321502	41311020	10/09/06

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
2.000	DAA-2-3	125" MILL 6061 T6	D2963125
Gross Weight	590 KGS		
Net Qty	571 KG	190 PC	603 M 2 PKG
Specification		Dis Desc	
AMS-QQ-A-200/8 & ASTM B221-00			

**Mechanical Tests:**

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	329.0 / 47.7	299.3 / 43.4	12.1	.0	95
2	354.5 / 51.4	318.7 / 46.2	13.1	.0	93

**Chemical Analysis:**

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.64	.23	.26	.08	.86	.06	.006	.05	.000	.010	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada